

It may be well to add that loose bushings ought to be marked with the size and kind of cutting tool for which they are intended; and the corresponding place in the jig body where they are to be used should be marked so that the right bushing can easily be placed in the right position.

A few more examples of open drill jig designs of various types may prove instructive. In Fig. 19 are shown two views of a jig for drilling two holes through the rim of a handwheel. To the left is shown the jig itself and to the right the jig with the hand-

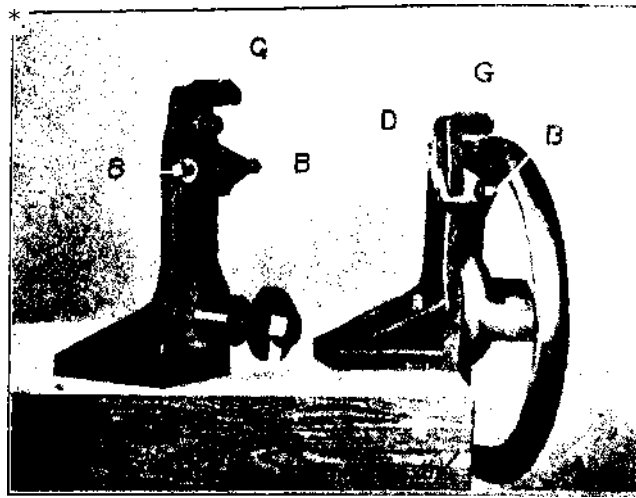


Fig. 19, Drill Jig for Holes in Rim of Handwheel

wheel mounted in place, ready for drilling. As shown, the hand-wheel is located on a stud through its bore, and clamped to the jig by passing a bolt through the stud, this bolt being provided with a split washer on the end. The split washer permits the easy removal of the handwheel when drilled, and the putting in place of another handwheel without loss of time. The hand-wheel is located by two set-screws *R* passing through two lugs projecting on each side of a spoke in the handwheel, the set-screws *B* holding the handwheel in position, while being drilled, by clamping against the sides of the spoke. The jig is fastened on the edge of the drill-press table, in a manner similar to that indicated in the illustration, so that the table does not interfere